

Push
Work Order ID 60927

July 27, 2010 7:01:52 AM



Page 1

Item ID: D4149-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Plate, Aft

Start Date: 7/27/10

Start Qty: 1.00



Cust Item ID:

Required Date: 7/27/10

Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *[Signature]*

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4149

B

0.00

100



Waterjet

0.00

FLOW CNC Waterjet

304 .126

Memo

Cut as per dwg D4149

Prog Rev: *B*

Dwg Rev: *B*

Deburr as required

SB 10/27/27

B10-7-27

(2)

(2)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-7-27

Work Order ID 60927

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Page 2

Item ID:	D4149-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Crosstube Lug Plate, Aft					
Start Date:	7/27/10	Start Qty:	1.00	Cust Item ID:		
Required Date:	7/27/10	Req'd Qty:	1.00	Customer:		
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>42</u>			
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> <u>B60779</u> Memo	0.00 0.00				<u>2</u>			
160 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

10/07/28

10-7-29

Picklist Print

July 27, 2010 7:01:51 AM

Page 1

Work Order ID: 60927



Parent Item: D4149-1



Parent Item Name: Crosstube Lug Plate, Aft

Start Date: 7/27/10

Required Date: 7/27/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S11GA

Purchased

No

100

sf

99.4009

0.1355

0.142632

3



304/316 0.125 Sheet



VB 10-7-07

Location

Loc Qty

Loc Code

MAT

99.4009

114488

1.5259

114799

97.875

114799

②

DART AEROSPACE LTD		Work Order: 60927
Description: CROSS-TUBE Lug PLATE ACT		Part Number: D4149-1
Inspection Dwg: D4149-1 Rev: B		Page 1 of 1

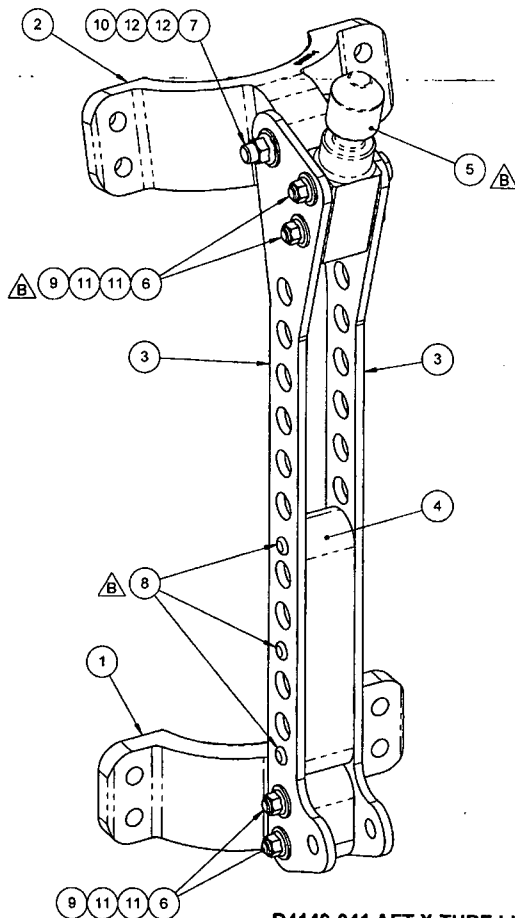
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .005 - .001	.130	✓		V 1B02	
Ø .191	+ .005 - .001	.194	✓		V	
Ø .257	+ .006 - .001	.259	✓		V	
Ø .38	+ .006 - .001	.379	✓		V	
.380	TL .010	.381	✓		V	
.469	TL .010	.471	✓		V	
.310	TL .010	.311	✓		V	
.750	TL .010	.750	✓		V	
3.25	TL .030	3.252	✓		V	
.65	TL .030	.643	✓		V	
.63	TL .030	.624	✓		V	
5.46	TL .030	5.456	✓		V	
3.80	TL .030	3.801	✓		V	
2.13	TL .030	2.122	✓		V	
1.313	TL .010	1.311	✓		V	
.625	TL .010	.622	✓		V	
.375	TL .010	.377	✓		V	
1.175	TL .010	1.174	✓		V	
.752	TL .010	.746	✓		V	
1.588	TL .010	1.583	✓		V	
1.587	TL .010	1.586	✓		V	
11.15	TL .030	11.158	✓		V PWJ 02 Prod-WJ-02	
.750	TL .010	.759	✓		V	

Measured by: RB	Audited by: S	Prototype Approval: N/A
Date: 10-7-27	Date: 12/07/27	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4149-041 AFT X-TUBE LUG ASSY


NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.17 lbs.

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	4	AN3C12A	
7	1	AN4C13A	BOLT
8	3	MS20615-4M18	RIVET
9	4	MS21043-3	NUT
10	1	MS21043-4	NUT
11	8	NAS1149C0332R	WASHER
12	2	NAS1149C0432R	WASHER

WLO 60927

RELEASED
2010-07-16
MP

	MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3909-5 (ZN D3-1 & D7-2); REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B3-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D8-3); REASON: SEE TR-D350-007-2 REV. B.	MB	10.07.05	
A	NEW ISSUE	MB	10.06.18	
REV.	DESCRIPTION	BY	DATE	
DESIGN	 DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B	SHEET 1 OF 5	
DRAWN				
CHECKED				DRAWING NO.
MFG. APPR.				D4149
APPROVED				TITLE
DE APPR.	AFT X-TUBE LUG ASSY	SCALE	NTS	
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AN4C13A BOLT
NAS1149C0432R WASHER, 2X
MS21043-4 NUT

D4149-5
EYEBOLT STUD

MS20615-4M18
RIVET
3 PL

D4091-1
MOUNTING LUG

D4149-1
AFT X-TUBE LUG PLATE
2 PL

D4149-3
SPACER

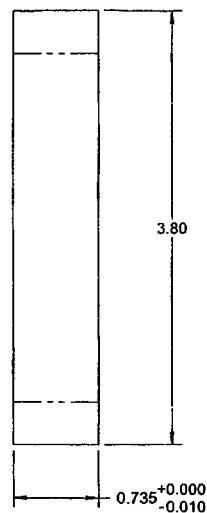
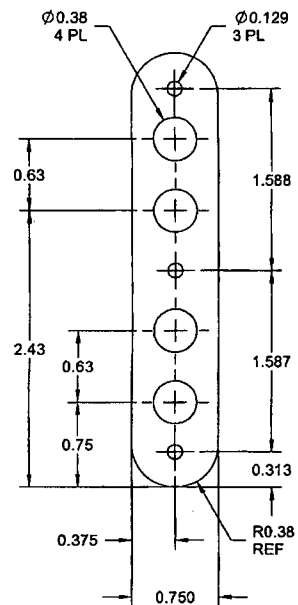
AN3C12A
NAS1149C0332R WASHER, 2X
MS21043-3 NUT
4 PL

D3910-1
X-TUBE LUG

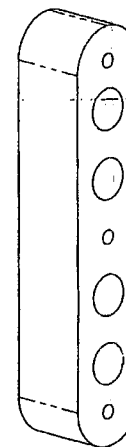
D4149-041 AFT X-TUBE LUG ASSY

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D4149-3 SPACER



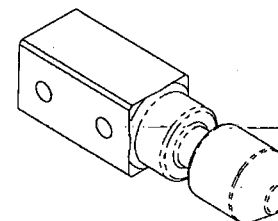
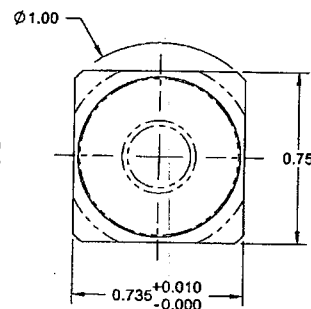
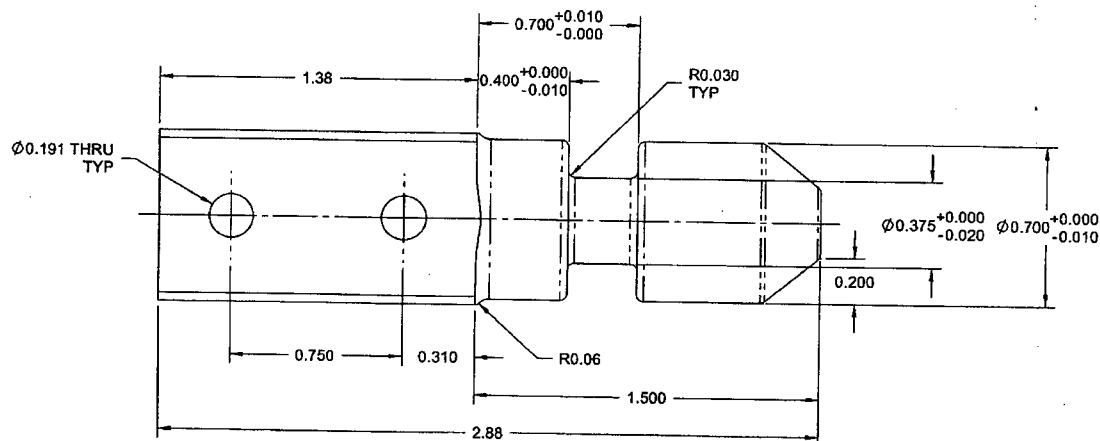
alb
60927

RELEASED
2010-07-16
JM

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.47 lbs

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MFG. APPR.	<i>[Signature]</i>	D4149	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AFT X-TUBE LUG ASSY	NTS
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D4149-5 EYEBOLT STUD

RELEASED
2010-07-16

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.33 lbs

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